

Work Order ID 86319

Wednesday, June 27, 2012 10:07:56 AM

86319

Page 1

Item ID: DSI 9410-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Modification

Start Date: 6/27/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *mf*Date: *12-06-27* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI 9410

B

100

0.00

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI 9410-011
CHG002

0.00

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

*AS 12/06/27**12/06/27*
*SP**(14)*

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Page 2

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4

Cust Item ID:

Required Date: 6/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9410-011

Location: 20PPP rev: A

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/04/12
MK
12-06-27

Picklist Print

Wednesday, June 27, 2012 10:07:56 AM

Page 1

Work Order ID: 86319
Parent Item: DSI 9410-011
Parent Item Name: Step Modification

Start Date: 6/27/2012
Start Qty: 4.00

Required Date: 6/27/2012
Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
by:EC IPP rev:B as per dwg RevB DD 10.03.03 verified

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN415A Bolt		Purchased	No			110	Each	722.0000	8	32			

Location	Loc Qty	Loc Code
358	100	
121652	100	
GA	100	
120449	100	
ST358	522	
118706	3	
120422	1	
121541	118	
122141	400	

AN960JD416
Washer

NAS1149D0463J Purchased No

110 Each 31.0000

Location	Loc Qty	Loc Code
ST351	31	
116289	10	
119097	21	

D2732-030
Rubber Cushion

Manufactured No

110 Each 30.0000

Location	Loc Qty	Loc Code
ST402	30	
84498	30	

D3595
Rubber Cushion (per sq ft)

Manufactured No

110 sf 334.1500

Location	Loc Qty	Loc Code
MAT052	334.15	
68954	334.15	

(D3595-200-300) Cut(2) at 2100" X 3100" as per dwg
D3595 (per kit)

32
32
16 64
16
4 16
0.0833 0.3332

11/21/912
B70987
B84209 12/6/27

Picklist Print

Wednesday, June 27, 2012 10:07:56 AM

Page 2

Work Order ID: 86319

Parent Item: DSI 9410-011

Parent Item Name: Step Modification

Start Date: 6/27/2012

Required Date: 6/27/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Nut

Purchased

No

110

Each

1,956.0000

32

12/6/278

Location

Loc Qty

Loc Code

ST300

1956

119075

116

121011

193

121444

1347

121652

300

32

Wednesday, June 27, 2012 10:07:56 AM

Shop Packet Print

Page 2

DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-591 REV. F

REF. CANADIAN STC: SH92-6

FAA STC: SH967NE

TO IMPROVE THE FIT OF THE D350-591-311/-312 STEPS, IT IS ACCEPTABLE TO INSTALL THE DSI 9410-011 KIT. INSTALL THE D2732-030 CUSHION (AFT CROSSTUBE) AND D3595-200-300 CUSHION (FWD CROSSTUBE) AS SHOWN IN FIGURE 1 IN PLACE OF THE D2856-400-720 ABRASION STRIP CALLED OUT ON DRAWING D350-591 REV. F.

FOR CUSTOMERS WHO HAVE PREVIOUSLY INSTALLED D2856-400-720 ABRASION STRIPS REMOVE THE ABRASION STRIPS IN ACCORDANCE WITH ICA-D350-591. PRIOR TO INSTALLING THE DSI 9410-011 KIT.

DSI 9410-011 KITS WILL BE INCLUDED WITH D350-591-311/-312 STEPS AT CHANGE 002 AND SUBSEQUENT.

QTY -041	PART NUMBER	DESCRIPTION
X	DSI 9410-011	STEP MODIFICATION KIT
4	D2732-030	CUSHION
7 2	D3595-200-300	CUSHION
8	AN4-15A	BOLT
16	AN960JD416	WASHER
8	MS21042L4	NUT (OR MS21042-4)

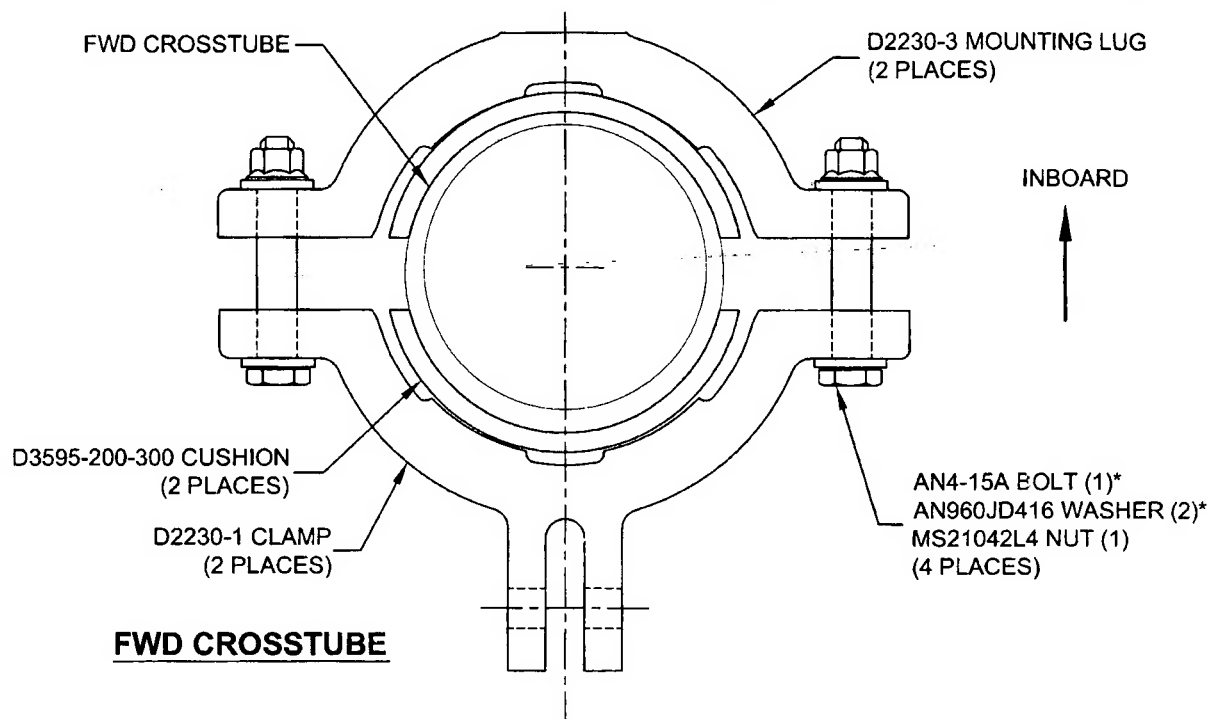
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

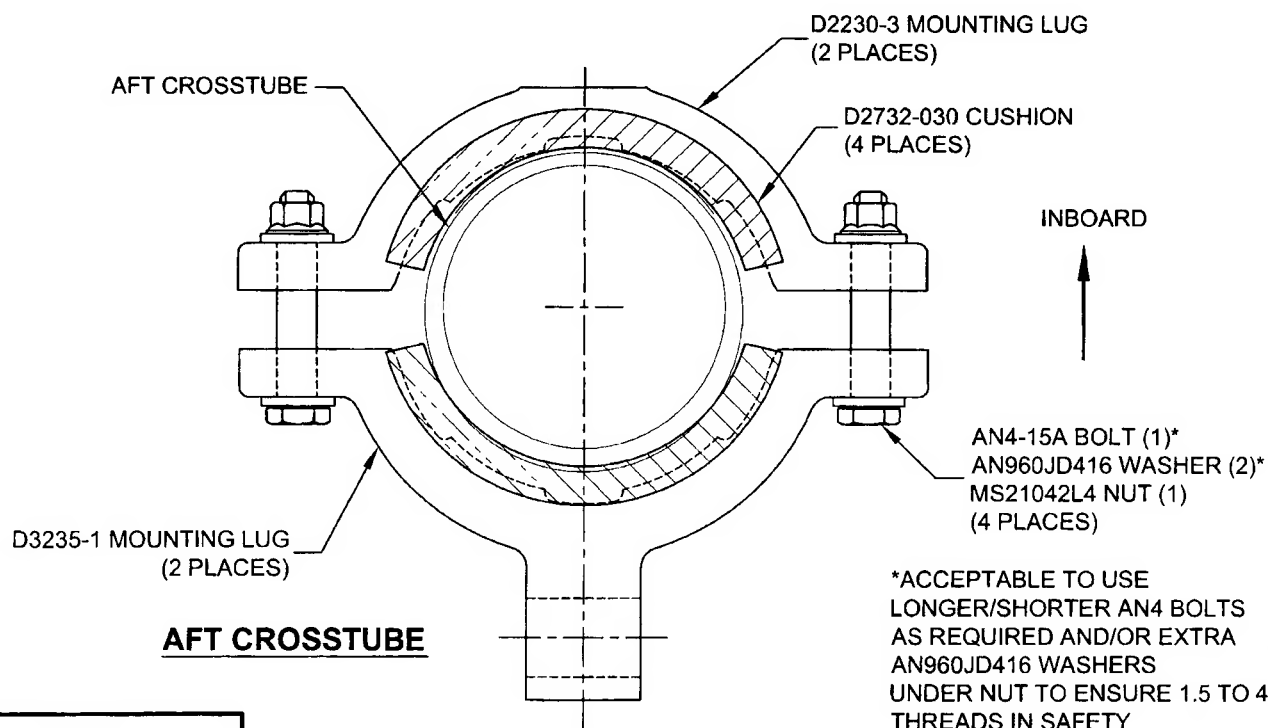
BY: 
D. SHEPHERD (DE # 02)

DATE: 08.09.08
CERT. NO.: SH92-6
ISSUE NO.: 10

B	SHEET 1 DELETE REVISED P/L. (SEPERATE DSI KIT FROM MAIN KIT SEE NCR 08-082 FOR DETAILS)	AJS	08.09.08
A	NEW ISSUE	PH	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9410	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	STEP MODIFICATION KIT	NTS
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FWD CROSSTUBE



AFT CROSSTUBE

*ACCEPTABLE TO USE
LONGER/SHORTER AN4 BOLTS
AS REQUIRED AND/OR EXTRA
AN960JD416 WASHERS
UNDER NUT TO ENSURE 1.5 TO 4
THREADS IN SAFETY

FIGURE 1 - CLAMP/CUSHION INSTALLATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.09.08
CERT. NO.: SH92-6
ISSUE NO.: 10

DESIGN	<i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AS</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9410	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STEP MODIFICATION KIT	NTS
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